

# Work Order ID 85645

\*85645\*

Page 1

Item ID: PB67-43001-275

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Item Name: Doubler

Stop \*NS2\*

Start Date: 6/12/2012 Start Qty: 5.00

\*5\*

Cust Item ID:

Required Date: 6/13/2012 Req'd Qty: 5.00

\*5\*

Customer:

Reference:

Approvals:

Process Plan:

*WMC*

Date:

12-06-12

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
B67-43001	C

100

0.00

\*100\*

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg  
Dwg Rev: *E*  
Prog Rev: *E*  
2-Deburr if necessary

*B2-6-12*

110

QC2- Inspect parts off machine FAI/FAIB

0.00

\*110\*

QC

Memo

0.00

Quality Control

*B2-6-12*

120

QC8- Inspect parts - second check

0.00

\*120\*

QC

Memo

0.00

Quality Control

*6*

*N N 12.06.13*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

*Tuesday, June 12, 2012 2:59:51 PM*

Page 2

**Accept**

Setup Start \*NS1\*

Stop \*NS2\*

**Start Date:** 6/12/2012      **Start Qty:** 5.00      **\*5\***

**Cust Item ID:**

**Required Date:** 6/13/2012      **Req'd Qty:** 5.00      **\*5\***

**Customer:**

**Reference:**

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

### Operation Description

### Set Up/ Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

130

Identify as per dwg & Stock Location: P.A.

0.00

**\*130\***

### Packaging

## Memo

0.00

### Packaging

140

QC21- Final Inspection - Work Order Release

0.00

**\*140\***

QC

## Memo

0,00

## Quality Control

12/6/14 ~~AD~~  
MS 12/06/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, June 12, 2012 2:59:51 PM

Page 1

Work Order ID: 85645  
Parent Item: PB67-43001-275  
Parent Item Name: Doubler

Start Date: 6/12/2012 Required Date: 6/13/2012  
Start Qty: 5.00 Required Qty: 5.00

Comments: IPP REV:A 12.06.05 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.125 6061-T6 .125 Sheet		Purchased	No			100	sf	53.0945	0.0168	0.0884211	1		
						<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>				
						MAT021		53.0945					
						121473		53.0945					

B-12-6-12

121473

(6)

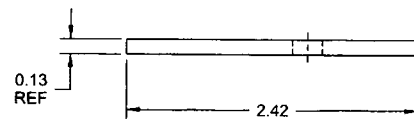
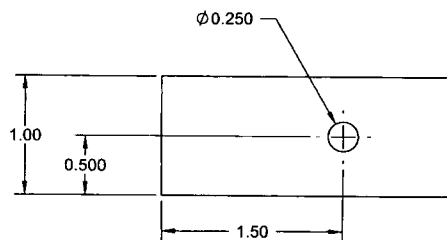
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

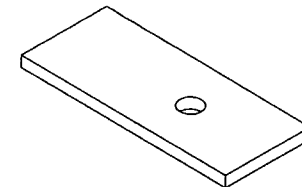
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**B67-43001-275 DOUBLER**

#85645



**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.250 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025/4027  
REF. DART SPEC. M6061T6S.250
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.03 lbs

**RELEASED**  
2009-09-24  
MD

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO PAGES 14 AND 34 OF PREMIER AVIATION DRAWING No. B67-43001. REPLACES "TRIMMED TO FIT" VERSION OF B67-43001-271. REASON: SEE PAR#09-011.		MB	09.03.11
REV.	DESCRIPTION		BY	DATE
DESIGN	RW	DART AEROSPACE LTD		
DRAWN		HAWKESBURY, ONTARIO, CANADA		
CHECKED	ASS	DRAWING NO.	REV. C	
MFG. APPR.		B67-43001-275	SHEET 1 OF 1	
APPROVED	MD	TITLE	SCALE	
DE APPR.	N/A	DOUBLER	NTS	
DATE	09.03.11		<small>COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



## David Duval

---

**From:** Marc Bellavance <mbellavance@dartaero.com>  
**Sent:** Tuesday, June 05, 2012 8:25 AM  
**To:** 'David Duval'  
**Cc:** astocker@dartaero.com; 'Mike Petsche'  
**Subject:** RE: B67-43001-275

David,

DWG is correct @ 0.13" thick.

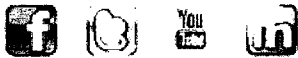


**Marc Bellavance**

*Technical/Shop Support*

T. 613-632-5200 C. 613-676-0992 F. 613-632-9311

1270 Aberdeen Street, Hawkesbury, Ontario, Canada, K6A 2K7



**Product Documentation: Verify Revision Status/Download [HERE!](#)**

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**From:** Mike Petsche [<mailto:mpetsche@dartaero.com>]  
**Sent:** Monday, June 04, 2012 4:58 PM  
**To:** David Duval  
**Cc:** Marc Bellavance; <[astocker@dartaero.com](mailto:astocker@dartaero.com)>  
**Subject:** Re: B67-43001-275

Can you pull one from stick to measure it?

Sent from my iPhone

On 2012-06-04, at 4:13 PM, "David Duval" <[dduval@dartaero.com](mailto:dduval@dartaero.com)> wrote:

So?

---

**From:** David Duval [<mailto:dduval@dartaero.com>]  
**Sent:** Monday, June 04, 2012 2:50 PM  
**To:** Marc Bellavance; [astocker@dartaero.com](mailto:astocker@dartaero.com)  
**Cc:** 'Mike Petsche'  
**Subject:**

What is the thickness of this part? In the notes it's 0.250" and on the dwg it's 0.13"

**David Duval**

*Production Engineering Coordinator*

<[image001.jpg](#)>

1270 Aberdeen Street

PR67-43001-274

[illegible]

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	